

Work Order ID 71681

Page 1

Thursday, July 07, 2011 12:12:56 PM

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CJ Date: 1107/07

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3259	Rev B

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

2024 063I-Cut as per Dwg D3259 Dwg Rev: B Prog Rev: B 02-
Deburr if necessary11-8-128

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

11-8-12

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

J wloriz(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Small Fab

Small Fab

Memo

1-C'Sink Holes as per Dwg D3259

0.00

140



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3259

0.00

150



QC



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Subtotal

(48)

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

170



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

180



Packaging

Identify as per dwg & Stock Location: ST 180a 0.00

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

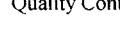
Stop

Sequence ID/
Work Center ID

190

Operation
Description

QC21- Final Inspection - Work Order Release

QC
Quality ControlSet Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

u/8/30 JH
ME
11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries

Picklist Print

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Thursday, July 07, 2011 12:12:54 PM

Work Order ID: 71681



Parent Item: D3259-3



Parent Item Name: Doubler

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	250.3800	1.388	11.68842	12.		

2024-T3 .063 sheet



Location	Loc Qty	Loc Code
MAT022	250.38	
117018	25.88	
117392	224.5	

117392

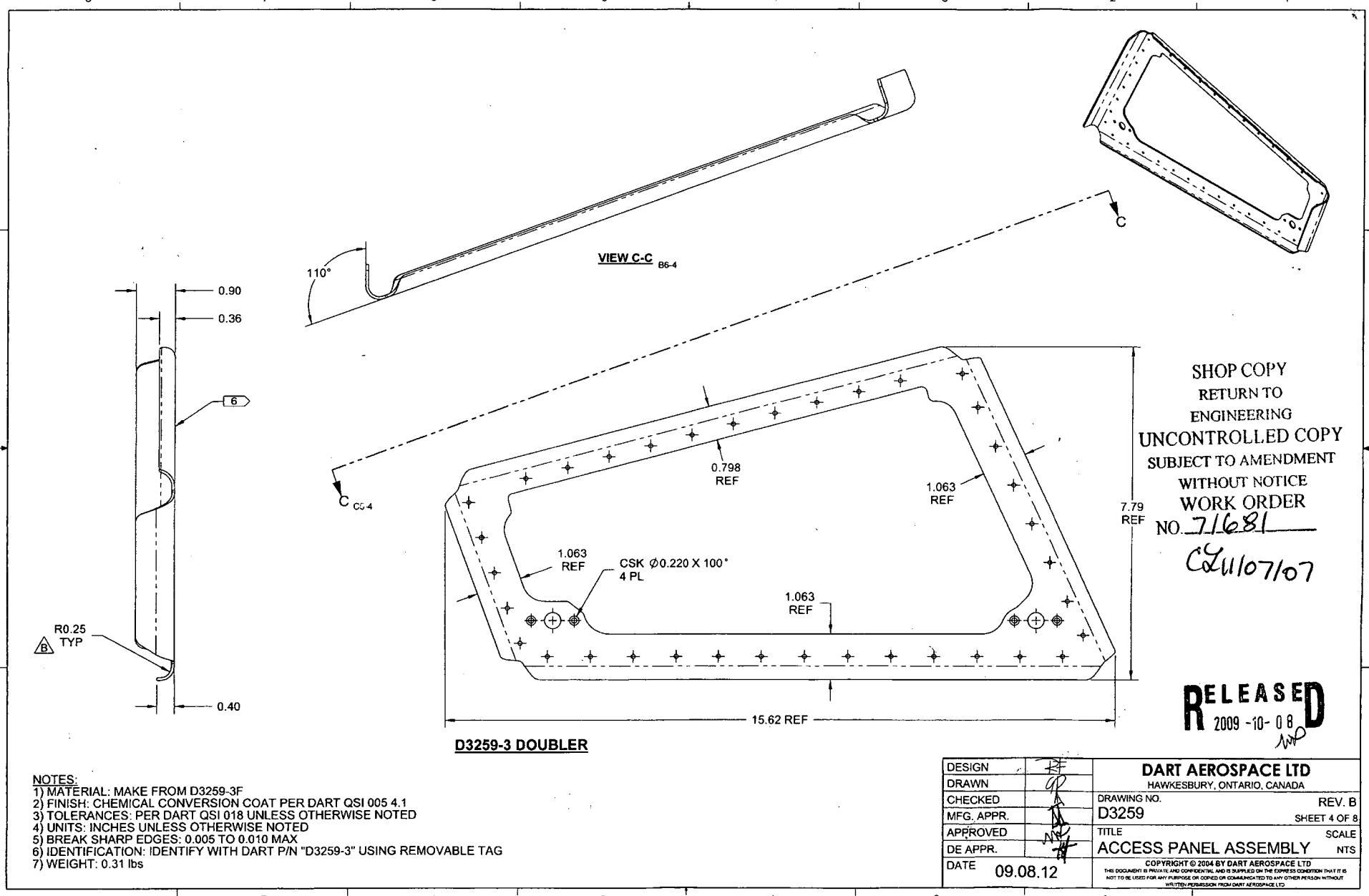
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date, & initial all entries



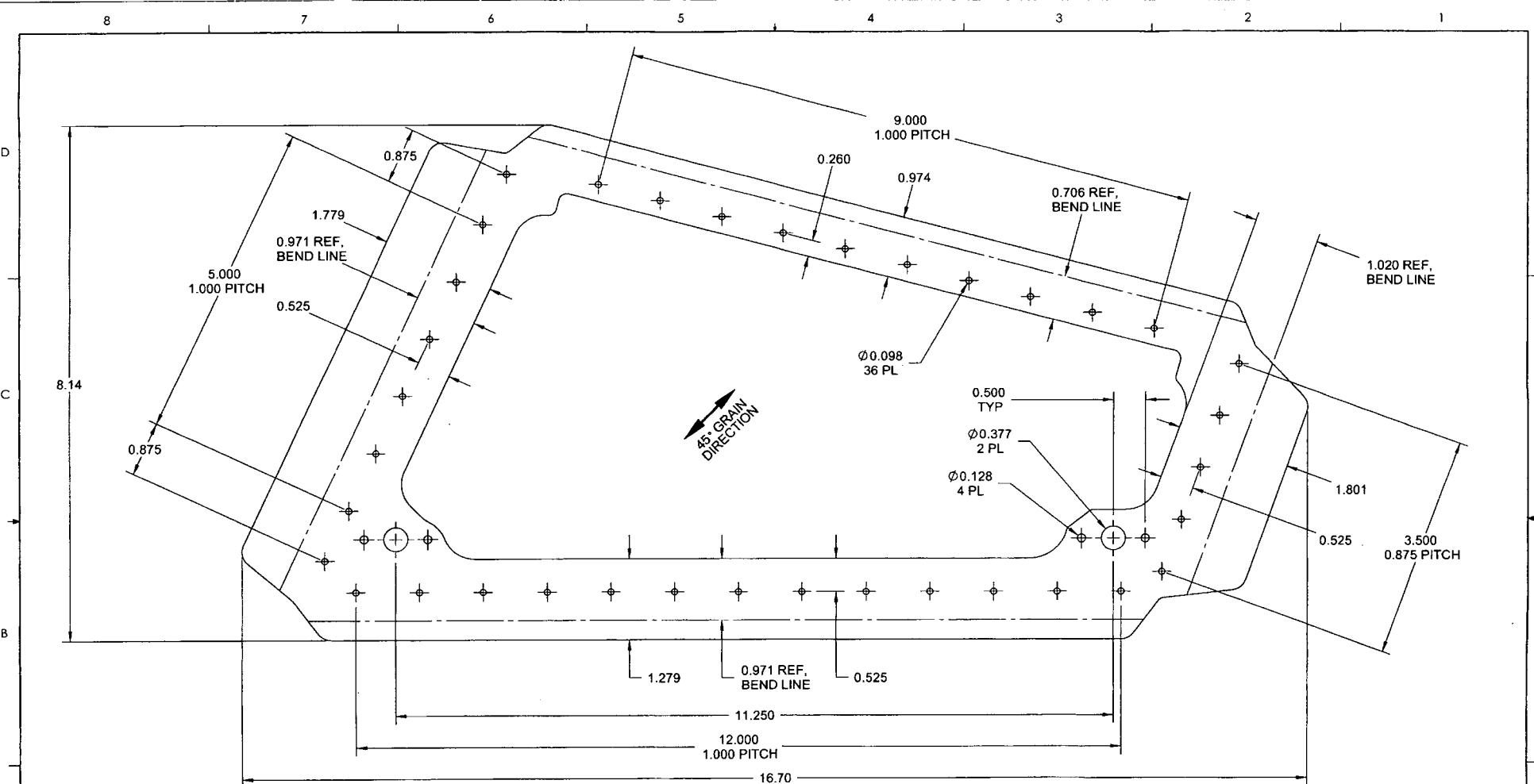
DART AEROSPACE LTD	Work Order:	71681
Description: Doubler	Part Number:	D3259-3/-4
Inspection Dwg: D3259	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.994	X		P R O W J C Z	
1.000	+/-0.005	1.006	X		U V B O Z	
0.260	+/-0.010	.258	X		V	
R0.25	+/-0.030	.25	X		R.G	
R0.50	+/-0.030	.50	X		R.G	
5.000	+/-0.005	4.996	X		V	
0.875	+/-0.005	.873	X		V	
12.000	+/-0.005	11.999	X		P	
3.500	+/-0.005	3.498	X		V	
0.875	+/-0.005	.876	X		V	
R0.13	+/-0.030	.13	X		R.G	
0.500	+/-0.005	.494	X		V	
0.525	+/-0.005	.524	X		V	
1.80	+/-0.030	1.804	X		V	
Ø0.128	+0.005/-0.000	.129	X		V	
Ø0.377	+0.005/-0.000	.377	X		V	
Ø0.098	+0.005/-0.000	.102	X		V	
0.063 thick	+/-0.005	.063	X		V	
Grain Direction	N/A		X			

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>11-8-17</u>	Date: <u>11/08/17</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	



D3259-3F DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3259
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 6 OF 8
DATE	09.08.12	TITLE
		SCALE
		NTS
		ACCESS PANEL ASSEMBLY

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2009-10-08
[Handwritten Signature]